TAPER

8 to 10 threads chamfered for easy thread starting in tough material.

PLUG

3 to 5 threads chamfered for general use when tapping to bottom of hole is not critical. This is the most popular tap of all three styles.

BOTTOM

1-1/2 threads chamfered for use after threads have been started. Used for clean tapping to bottom of holes.

NC = National Course
NF = National Fine

Packaging:
Sizes
0-80 ➔ 1/2”-20
5 / box

Sold Individually over 1/2”-20.

DRILL THIS SIZE HOLE			TO TAP FOR THIS BOLT OR SCREW
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.0469”	3/64”	3/64”	0-80 NF
.0595”	No. 53	none	1-64 NC
.0595”	No. 53	1/16”	1-72 NF
.0700”	No. 50	none	2-56 NC
.0700”	No. 50	none	2-64 NF
.0785”	No. 47	5/64”	3-48 NC
.0820”	No. 45	none	3-56 NF
.0860”	No. 44	none	4-36 NS
.0890”	No. 43	3/32”	4-40 NC
.0935”	No. 42	3/32”	4-48 NF
.0984”	2.5mm	none	3mm-0.60mm
.1015”	No. 38	none	1/8-40 NS
.1015”	No. 38	none	5-40 NC
.1040”	No. 37	none	5-44 NF
.1100”	No. 35	7/64”	6-32 NC
.1110”	No. 34	none	6-36 NS
.1130”	No. 33	none	6-40 NF
.1200”	No. 31	none	6-48 NS
.1338”	3.4mm	none	4mm-0.70mm
.1338”	3.4mm	none	4mm-0.75mm
.1360”	No. 29	none	8-32 NC
.1360”	No. 29	9/64”	8-36 NF
.1405”	No. 28	none	8-40 NS
.1470”	No. 26	none	3/16-24 NS
.1495”	No. 25	5/32”	10-24 NC
.1570”	No. 22	none	3/16-32 NS
.1590”	No. 21	5/32”	10-32 NF
.1653”	4.2mm	none	5mm-0.90mm
.1693”	4.3mm	none	5mm-0.80mm
.1770”	No. 16	11/64”	12-24 NC
.1820”	No. 14	3/16”	12-28 NF
.1850”	No. 13	none	12-32 NEF
.1935”	No. 10	none	14-20 NS
.2010”	No. 7	13/64”	1/4-20 NC
.2010”	No. 7	none	14-24 NS
.2047”	5.2mm	none	6mm-1.00mm
.2090”	No. 4	none	1/4-24 NS
.2130”	No. 3	7/32”	1/4-28 NF
.2188”	7/32”	7/32”	1/4-32 NEF
.2280”	No. 1	none	1/4-40 NS
.2401”	6.1mm	15/64”	7mm-1.00mm
.2570”	Ltr. F	17/64”	5/16-18 NC
.2716”	6.9mm	17/64”	8mm-1.25mm
.2720”	Ltr. I	none	5/16-24 NF
.2795”	7.1mm	none	8mm-1.00mm
.2812”	9/32”	9/32”	5/16-32 NEF
.3110”	7.9mm	none	9mm-1.25mm
.3125”	5/16”	5/16”	3/8-16 NC

DRILL THIS SIZE HOLE			TO TAP FOR THIS BOLT OR SCREW
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.3189”	8.1mm	none	9mm-1.00mm
.3268”	8.3mm	none	9mm-0.75mm
.3320”	Ltr. Q	21/64”	3/8-24 NF
.3425”	8.7mm	none	10mm-1.50mm
.3503”	8.9mm	11/32”	10mm-1.25mm
.3583”	9.1mm	none	*10mm-1.00mm
.3680”	Ltr. U	23/64”	7/16”-14 NC
.3818”	9.7mm	none	11mm-1.50mm
.3906”	25/64”	25/64”	7/16-20 NF
.4133”	10.5mm	none	12mm-1.75mm
.4212”	10.7mm	27/64”	12mm-1.50mm
.4219”	27/64”	27/64”	1/2-13 NC
.4291”	10.9mm	27/64”	*12mm-1.25mm
.4531”	29/64”	29/64”	1/2-20 NF
.4531”	29/64”	29/64”	1/2-24 NS
.4803”	12.2mm	none	14mm-2.00mm
.4844”	31/64”	31/64”	9/16-12 NC
.4999”	12.7mm	none	14mm-1.50mm
.5039”	12.8mm	none	*14mm-1.25mm
.5156”	33/64”	33/64”	9/16-18 NF
.5312”	17/32”	17/32”	5/8-11 NC
.5590”	14.2mm	35/64”	16mm-2.00mm
.5781”	37/64”	37/64”	5/8-18 NF
.5787”	14.7mm	none	16mm-1.50mm
.5938”	19/32”	19/32”	11/16-11 NS
.6220”	15.8mm	39/64”	18mm-2.50mm
.6250”	5/8”	5/8”	11/16-16 NS
.6562”	21/32”	21/32”	3/4-10 NC
.6614”	16.8mm	none	*18mm-1.50mm
.6875”	11/16”	11/16”	3/4-16 NF
.7008”	17.8mm	11/16”	20mm-2.50mm
.7656”	49/64”	49/64”	7/8-9 NC
.8125”	13/16”	13/16”	7/8-14 NF
.8228”	20.9mm	none	22mm-1.50mm
.8281”	53/64”	53/64”	*7/8-18 NS
.8425”	21.4mm	53/64”	24mm-3.00mm
.8750”	7/8”	7/8”	1-8 NC
.8779”	22.3mm	none	24mm-2.00mm
.9219”	59/64”	59/64”	1-12 NF
.9375”	15/16”	15/16”	1-14 NS
.9844”	63/64”	63/64”	1-1/8 - 7 NC
1.0469”	1-3/64”	1-3/64”	1-1/8 - 12 NF
1.1094”	1-7/64”	1-7/64”	1-1/4 - 7 NC
1.1719”	1-11/64”	1-11/64”	1-1/4 - 12 NF
1.2188”	1-7/32”	1-7/32”	1-3/8 - 6 NC
1.2969”	1-19/64”	1-19/64”	1-3/8 - 12 NF
1.3468”	1-11/32”	1-11/32”	1-1/2 - 6 NC
1.4219”	1-27/64”	1-27/64”	1-1/2 - 12 NF

*** Spark Plug Taps.**

NPT Tap-Drill Chart
Available on Page 36.